

Work Order ID 62539

Monday, October 04, 2010 10:54:47 AM



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Item ID: D119-646-451

Accept



Setup Start



Revision ID:

Stop



Item Name: Wearplates, LH, OEM

Start Date: 10/4/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 10/20/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan: *N* Date: 10-10-04

Tooling:

Date:

Run Start

QC: Date: SPC (Y/N): Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
DSI 9526	A								
100		0.00							
	DOCUMENT CONTROL								
DC	Memo	0.00							
Document Control	Photocopy blue file & type labels as per PPP D119-646-451/ DSI 9526 001								
110		0.00							
	Pick Kit								
Packaging	Memo	0.00							
Packaging									
120		0.00							
	QC4- 100% Inspect kits for completeness								
QC	Memo	0.00							
Quality Control									

*S10/10/14**for BG 10-10-12**10/10/12 10**S10/10/14*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item Name: Wearplates, LH, OEM

Start Date: 10/4/2010 Start Qty: 1.00

Cust Item ID:

Required Date: 10/20/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 	Packaging	0.00							
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D119-646-451/ DSI 9526 Location: _____ PPP rev: <u>A</u>								
140 	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

10/10/14

10/10/18

10-10-15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 62539

Parent Item: D119-646-451

Parent Item Name: Wearplates, LH, OEM






Start Date: 10/4/2010

Required Date: 10/20/2010

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 10.06.25 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4132-041  Wearplate, LH Fwd		Manufactured	No			110	Each	2.0000	1	1		10/10/12	SP
<div>Location</div> <div>ST 165</div> <div>62318</div>													
							2			1			
							2			1			
D4133-041  Wearplate, Mid		Manufactured	No			110	Each	2.0000	1	1		10/10/12	SP
<div>Location</div> <div>ST 165</div> <div>62155</div>													
							2			1			
							2			1			
D4134-041  Wearplate, LH Aft		Manufactured	No			110	Each	1.0000	1	1		10/10/12	SP
<div>Location</div> <div>ST</div> <div>62157</div>													
							1			1			
							1			1			
D4135-1  Wearpad		Manufactured	No			110	Each	2.0000	3	3		10/10/12	SP
<div>Location</div> <div>FG</div> <div>60167</div>													
							2			2			
							2			2			
ALS-1032-130 AELS-1032-130  INSERT		Purchased	No			110	Each	0.0000	20	20		11/15/79	10/10/12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 62539

Parent Item: D119-646-451

Parent Item Name: Wearplates, LH, OEM

Start Date: 10/4/2010

Required Date: 10/20/2010

Start Qty: 1.00

Required Qty: 1.00

ALS7									
AEELS-1032-225	Purchased	No	110	Each	0.0000	12	12		
INSERT									
AN3C5A	Purchased	No	110	Each	842.0000	54	54		
Bolt									

M102078 10/10/10
10/10/10

Location Loc Qty Loc Code

ST350	832	
114330	11	
115015	16	
115316	105	
115371	100	
115422	100	
115594	500	
ST351	10	
113121	10	

34

1									
NAS1149C0332R	Purchased	No	110	Each	1,799.000	54	54		
Washer									

10/10/10 sf 10

Location Loc Qty Loc Code

ST297	1799	
113524	10	
113737	150	
115000	125	
115698	114	
115816	1400	

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Shop Packet Print

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

REFERENCE ONLY

PARTS LIST

QTY -451	QTY -452	PART NUMBER	DESCRIPTION
X		D119-646-451	WEARPLATE KIT, OEM LH
	X	D119-646-452	WEARPLATE KIT, OEM RH
1		D4132-041 /	WEARPLATE, FWD LH
1		*D4132-3	GASKET (BONDED WITH 3M 1300/1300L)
	1	D4132-042	WEARPLATE, FWD RH
	1	*D4132-3	GASKET (BONDED WITH 3M 1300/1300L)
1	1	D4133-041	WEARPLATE, MID
1	1	*D4133-3	GASKET (BONDED WITH 3M 1300/1300L)
1		D4134-041	WEARPLATE, AFT
1		*D4134-3	GASKET (BONDED WITH 3M 1300/1300L)
	1	D4134-042	WEARPLATE, AFT
	1	D4134-3	GASKET (BONDED WITH 3M 1300/1300L)
3	3	D4135-1	WEARPAD
20	20	AELS-1032-130	INSERT
12	12	AELS-1032-225	INSERT
54	54	AN3C5A /	BOLT
54	54	NAS1149CO332R /	WASHER

* denotes that part is included in assembly above

WEIGHT AND BALANCE

The following weight and balance information is for the Dart D119-646-451/-452 kits only. The weight and balance of the wearplates removed are the responsibility of the installer.

Installation	Weight	LONGITUDINAL		LATERAL	
		Arm	Moment	Arm	Moment
D119-646-451 WEARPLATE KIT, LH	10.8 lb 4.9 kg	117.7 in 2.99 m	1271 in lb 14.7 m kg	-39.4 in -1.00 m	-426 in lb -4.9 m kg
D119-646-452 WEARPLATE KIT, RH	10.8 lb 4.9 kg	117.7 in 2.99 m	1271 in lb 14.7 m kg	+39.4 in +1.00 m	+426 in lb +4.9 m kg

DESIGN	92	DART AEROSPACE USA, INC	
DRAWN	92	PORT HADLOCK, WA	
CHECKED	H	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9526	SHEET 2 OF 3
APPROVED	H	TITLE	SCALE
DE APPR.	H	OEM WEARPLATE KIT	NTS
DATE	10.06.11		<small>COPYRIGHT © 2010 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>